

SHIP 3-22

SOLD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-636-012
Job Sheet 172902

**Part No:** D350-636-012**Job Qty:** 1 pcs**Part Name:** Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 2/22/18**Job Tracking No:****Due Date:** 3/22/18**Created By:** Logan David**Type:** SOLD**Description:**

Note: DWG D3492 REV E SHEET 1, D2750-042 REV G SHEETS 1,2,5,9 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP Rev:P 10.06.22 revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R 13.08.27 PER ECN13-594 DD VERF:JLM

Ship Via:**Bill of Materials****Container No:** S048472**Part:** D350-636-012**Job No:** 172902**Serial No/Batch:** S048472**Revision:**
Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/06/18

SCRAP

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/21/18	0.00	0.00	Start Up Skid tubes-1		JW
110	Skid tubes	1 pcs		3/21/18	0.00	4.36	Skid tubes-4		DAG
120	QC	1 pcs		3/21/18	0.00	0.00	QC10		38
130	QC	1 pcs		3/21/18	0.00	0.00	QC5		9-88 DAG
140	HandFinish	1 pcs		3/21/18	0.00	0.91	HandFinish1		38
150	QC	1 pcs		3/21/18	0.00	0.00	QC7-2		9-88
160	Skid tubes	1 pcs		3/21/18	0.00	4.36	Skid tubes-1		JW
170	QC	1 pcs		3/21/18	0.00	0.00	QC10		
180	QC	1 pcs		3/21/18	0.00	0.00	QC5		
190	HandFinish	1 pcs		3/21/18	0.00	0.91	HandFinish2		
200	SprayPaint	1 pcs		3/21/18	0.00	0.69	Spray Paint		
210	QC	1 pcs		3/21/18	0.00	0.00	QC14		
230	HandFinish	1 pcs		3/22/18	0.00	0.91	HandFinish4		
240	QC	1 pcs		3/22/18	0.00	0.00	QC5		
250	Packaging	1 pcs		3/22/18	0.00	0.00	Packaging1-3		
260	QC	1 pcs		3/22/18	0.00	0.00	QC4		
265	DC	1 pcs		3/22/18	0.00	0.00	DC		
270	Packaging	1 pcs		3/22/18	0.00	0.00	Packaging3-1		
280	QC21-FG	1 Ea		3/22/18	0.00	0.00	QC21		
330	Packaging	1 pcs		3/22/18	0.00	0.00	Packaging2		

Part Op 110 - 1- Pick D2600-3 Bent Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & Descriptions: DT8863A for second side only DT8863B for first side (detail K) 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 7- Open up holes of Detail J to 0.297" (total of 2 holes per side) 8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 9- Grind welds flush as per Dwg D2750

160 - 1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float holes using uni-bit to .500" (4 per Side) 4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: exp. date: ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: 9- At section AP-AP drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11- Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12- Deburr holes, ensure tube is free of all scratches before sending to paint.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH:

210 - Inspect for foreign object per QSI 024

230 - 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: EXP DATE: 4- assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 5-Coat all exposed fasteners with "LPS Procyon" batch:

265 - Record fwd angle: Photocopy blue file and type labels per PPP D350-636-012 CHG 007

270 - Package as per PPP D350-636-012

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	1 Ea (1 ea)	90-Start up Operation	5043941
D2744	Cap	1 Ea (1 ea)	90-Start up Operation	5038835
D2739	350 I-Beam	1 Ea (1 ea)	160-Skidtubes	5040982
D2743	Crossbolt Spacer	8 Ea (8 ea)	160-Skidtubes	5008679
D3490-1	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5039269
D3490-3	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5040318
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish	
AN3C5A	Bolt	34 Ea (34 ea)	230-HandFinish	
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	
D3488-042	Blade Fitting RH	1 Ea (1 ea)	230-HandFinish	
D3492-1	Plug	8 Ea (8 ea)	230-HandFinish	
D3492-3	Plug	8 Ea (8 ea)	230-HandFinish	
D3535-25	Wearplate Center	1 Ea (1 ea)	230-HandFinish	
D3536-25	Gasket Center	1 Ea (1 ea)	230-HandFinish	
D3537-1	Wearpad	3 Ea (3 ea)	230-HandFinish	
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish	
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish	
D3793-1	Wearplate Fwd	1 Ea (1 ea)	230-HandFinish	
D3793-3	Wearplate Aft	1 Ea (1 ea)	230-HandFinish	
D3794-1	Gasket Fwd	1 Ea (1 ea)	230-HandFinish	
D3794-3	Gasket Aft	1 Ea (1 ea)	230-HandFinish	
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish	
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish	
NAS1611-013	O-Ring	8 Ea (8 ea)	230-HandFinish	
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging	
D3493-1	Washer	2 Ea (2 ea)	250-Packaging	
D3532-1	Spacer	2 Ea (2 ea)	250-Packaging	
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-RH	1	16	0
	D2744	1	28	0
160-Skidtubes	D2739	1	27	0
	D2743	8	151	0
	D3490-1	4	128	0
	D3490-3	4	107	0
230-HandFinish	ALS4-1032-225	38	1,075	0
	AN3C5A	34	805	0
	AN3C6A	4	170	0
	AN6C44A	4	447	0
	AN8C35A	1	73	0
	D2745	8	105	0
	D3488-042	1	14	0
	D3492-1	8	199	0
	D3492-3	8	152	0
	D3535-25	1	25	0
	D3536-25	1	16	0
	D3537-1	3	103	0
	D3631-1	8	54	0
	D3791-1	1	11	0
	D3793-1	1	27	0
	D3793-3	1	30	0
	D3794-1	1	20	0
	D3794-3	1	10	0
	MS21043-6	4	119	0
	MS21083C8	1	91	0
	NAS1149C0332R	38	4,708	0
	NAS1149C0832R	1	98	0
	NAS1515H3L	4	295	0
	NAS1611-010	8	279	0
	NAS1611-013	8	367	0
250-Packaging	AN8C21A	2	166	0
	D2741	1	82	0
	D3493-1	2	40	0
	D3532-1	2	56	0
	MS21083C8	2	91	0
	NAS1149D0863J	2	167	0

Part Specifications

Specifications could not be found.

Plex 2/22/18 2:13 PM dart.logan.david

WORK ORDER NON-CONFORMANCE / UPDATE

AEROSPACE

QA Closed:

Date:

Work Order update only

Work Order: <u>172902</u> Part No. <u>D350-636-012</u> NCR No.		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☒ Cross tube ☐ Machining ☐ Small Fab ☐ Thermoforming ☐ Finishing ☐ Large Fab ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #: <u>160</u>		QTY Effective : <u>1</u>				MRB (QSI042) Approval DAS 9 9-89 <u>18-05-15</u>			
Description Work Order Deviation				Disposition				Completed By			
WEB improperly located / Moved position ↳ BLADE fitting wont fit, bent WEB				SCRAP				Lead hand / Supervisor Approval Verification <u>JW</u> <u>18-05-15</u>			
								QC / QA Coordinator Approval DAS 9 9-89 <u>18-05-15</u>			
Root Cause Environment ☐ No Re-verification ☐ Design ☒ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☒ Bending ☐ Set-up ☐ Folio/Program ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Crushing ☐ Countersink ☒ Off-set ☐ Heat Treat ☐ Cut Too Short ☐ Mislabelled ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ OTHER :						Positioned Wrong ☒ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	